



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4895-045
Job Sheet 168175



Part No: D4895-045
Part Name: Fwd Outboard Beam Assembly

Job Qty: 2 ea



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/27/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/26/17	0.00	0.00	Start Up Waterjet1		ac 17/12/04
100	Waterjet	2 pcs		12/26/17	0.00	1.68	Waterjet1		ac 17/12/04
110	CNC Vertical Machining	2 pcs		12/26/17	1.13	6.67	HAAS 1		DAS 1 17-12-21
120	QC	2 pcs		12/26/17	0.00	0.00	QC2		1989 17-12-27
150	QC	2 pcs		12/26/17	0.00	0.00	QC8		17-12-27
160	HandFinish	2 pcs		12/26/17	0.00	0.49	HandFinish1		17-12-27
170	QC	2 pcs		12/26/17	0.00	0.00	QC7		17-12-27
171	Powdercoat	2 pcs		12/26/17	0.00	0.24	Powdercoat1		17-12-27
172	QC	2 pcs		12/26/17	0.00	0.00	QC3		17-12-27
180	Small Fab	2 pcs		12/27/17	0.00	0.37	Small Fab		DAS 17-12-27
190	QC	2 pcs		12/27/17	0.00	0.00	QC5		17-12-27
200	Packaging	2 pcs		12/27/17	0.00	0.00	Packaging3	STY 18	AT 18/01/22
210	QC21-SA	2 Ea		12/27/17	0.00	0.00	QC21		21 18-01-22

M 138467 JART: 8:40 O.V.T. 3200 FINISH: 9:10. JAN 22 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X12.000	6	33	0	0
180-Small Fab	D4859-1	8	12	0	0

1147406

Part Specifications

Specifications could not be found.

Plex 11/10/17 11:02 AM dart.poulin.mario

5h30 de machinerie
+ 0465x90°

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ M. _____ ☐ Therm _____ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____			
Description Work Order Deviation					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Ter ☐ Set ☐ BO ☐ Br ☐ In ☐ Co ☐ Cr ☐ C ☐ Ir ☐ C ☐	

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DART
 AEROSPACE
S017153



Fwd Outboard Beam Assembly

D4895-045

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 12/04/17
 Job No: 168175

(QS1042) Approval

Completed By

Hand / Supervisor
 Approval Verification

QC / QA Coordinator
 Approval

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

DART AEROSPACE LTD		Work Order:	168175
Description: Fwd Outboard Beam		Part Number:	D4895-5
Inspection Dwg: D4895	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.55	✓		tape	—
	R0.38	+/-0.030	0.380	✓		R-G	—
	0.85	+/-0.030	0.860	✓		Kt-05	verm
	0.93	+/-0.030	0.909	✓		" "	" "
	8.32	+/-0.030	8.316	✓		31006	H-G
	Ø0.425	+0.000/-0.002	0.424	✓		Pin	—
	0.750	+/-0.010	0.752	✓		Kt-05	verm
	0.200	+/-0.010	0.204	✓		" "	" "
	R0.43	+/-0.030	0.430	✓		R-G	—
	3.00	+/-0.030	3.000	✓		Kt-05	verm
	3.50	+/-0.030	3.500	✓		" "	" "
	0.15	+/-0.030	0.154	✓		G5011351	micro
	0.250	+/-0.010	0.252	✓		Kt-05	verm
	5.75	+/-0.030	5.750	✓		" "	" "
	1.34	+/-0.030	1.340	✓		31006	H-G
	1.00	+/-0.030	1.000	✓		Kt-05	verm
	R0.13	+/-0.030	0.125	✓		R-G	—
	0.150	+/-0.010	0.150	✓		B5011351	micro
	1.15	+/-0.030	1.150	✓		Kt-05	verm
	3.00	+/-0.030	3.000	✓		" "	" "
	Ø0.377	+0.005/-0.001	0.377	✓		" "	" "
	3.50	+/-0.030	3.500	✓		" "	" "
	1.75	+/-0.030	1.750	✓		" "	" "
	3.600	+/-0.005	3.600	✓		" "	" "
	1.800	+/-0.005	1.800	✓		" "	" "
	0.80	+/-0.030	0.800	✓		" "	" "
	0.60	+/-0.030	0.600	✓		" "	" "
	2.300	+/-0.005	2.300	✓		" "	" "
	Ø1.00	+/-0.030	1.001	✓		" "	" "
Manual Mill	0.25	+/-0.030	0.250	✓		31006	H-G
	5.50	+/-0.030	5.519	✓		Kt-05	verm
	12.000	+/-0.005	12.000	✓		" "	" "
	1.55	+/-0.030	1.550	✓		" "	" "
	Ø0.465 X 90°	+/-0.010 x 0.5°	Ø0.465 x 90°	✓		" "	" "
	R0.25	+/-0.030	0.250	✓		R-G	—
	0.500	+/-0.010	0.500	✓		Kt-05	verm

Measured by:	1 9-89 KJ	Audited by:	B.A	Preliminary Approval:	
Date:	17-12-21	Date:	17-12-27	Date:	

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	



Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4895-045 Revision: Fwd Outboard Beam Assembly														
210	QC21-SA	S017153	168175	2 Ea	0	S017153	ST448	Bin	Stock	12/4/2017	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: M6061T6B1.000X12.000 Revision: 6061-T6 Bar 1.00 X 12.00														
100	Receive Ft	S017152	168175	0 ft	0	M138429	Start Up Waterjet		Stock	12/4/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		2	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					